

Date: Friday, 3/2/2007 10:35:12 AM  
 User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : X-TUBE AS 350/355 HI FWD UNDER REVIEW
Job Number : 31013A	
Estimate Number : 12484	
P.O. Number :	Part Number : D350748141
This Issue : 3/2/2007 S.O. No. :	Drawing Number : D350-748-141 U/R
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : C
Previous Run : 31012A	Material :
Written By :	Due Date : 3/30/2007 Qty: 1 Um: Each
Checked & Approved By : <u>07.03.02</u>	
Comment : Est Rev: A New Issue 06-07-05 JLM	
Est Rev: B Update cadplate process 06-09-12 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-141 CHG001

2.0	D6017115	Crosstube Material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Crosstube Material

D6017-115

2.339" OD X 2.000" ID

Batch: B27471

07/03/07

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
-----	------------	----------------------------



Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs on both ends as per Folio FA648

2-Turn first side as per Folio FA648

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

07/03/07

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
-----	-----	------------------------------



Comment: INSPECT ALL DIM TO DIM SHEET

07-03-07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 3/2/2007 10:35:12 AM  
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## Process Sheet

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Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31013A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA648

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-141.

3-Scribe Part & Batch as per Dwg D350-748-141

2.5 07/23/05 (1)

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

2.5 07/03/05 (1)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

3.5 07/03/05 (1)

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

DP 50 7-3-7

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3281

Heat Treat to min 180 KSI As per Dwg D350-748-141

(MIL-T-6736 OR AMS 2759-1C)

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

C 207/03/12 (1)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformaty is attached

2.5 7/3/20 (1)  
2.5 7/4/23 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Date: Friday, 3/27/2007 10:35:12 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI FWD UNDER REVIEW

Job Number: 31013A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC6

DIMENSIONAL CHECK



7-04-25(1)



Comment: DIMENSIONAL CHECK

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-141 using CNC bender program D350F and Folio FT

EL

7-4-26

13.0

QC5

INSPECT WORK TO CURRENT STEP



7-05-02



Comment: INSPECT WORK TO CURRENT STEP

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill Tube as per Dwg D350-748-141 Using DT8876 Drill Jigs,  
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-141

4-Remove all marks from tube within limits of D350-748-141

5- Apply a light coat of LPS3 on the interior of tube

Batch: 104161

R/EL

070430

RT 07-05-07

SD 7-5-4

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

07/05/08

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3730

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possibe Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

07/05/09

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 31013A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Receive & Inspect For Transit Damage  
Ensure certificate of conformity is attached

07/06/04 @

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-06-04 @

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Prime Outside of Tube as per Dart QSI 005 4.2

} RT 07-06-06

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint  
Then, Wrap in plastic bag to protect from scratches

07-06-07 @

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

SUPPORT

Batch: 28476

RT 07-06-09

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total : 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 32020

25 07 06 -09

23.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Insert

Batch: 19393

RT 07 06 09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

(A)

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

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Job Number: 31013A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description:

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 104118

RT 07-06-09

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 102712

RT 07-06-09

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 18836

RT 07-06-09

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-141 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-141, Torque to 60-80 IN-LBS

} RT 07-06-13

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

June 14 @

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

PPP B 31013

Include OSI 9381  
6/7/14

## WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 31013A

Part Number: D350748141

Job Number:



Seq. #:

Machine Or Operation:

Description :

30 0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>31013A</b>
<b>Description:</b> Crosstube Assembly (AS350/355 High Fwd)	<b>Part Number:</b>	<b>D350-748-141</b>
<b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> C		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

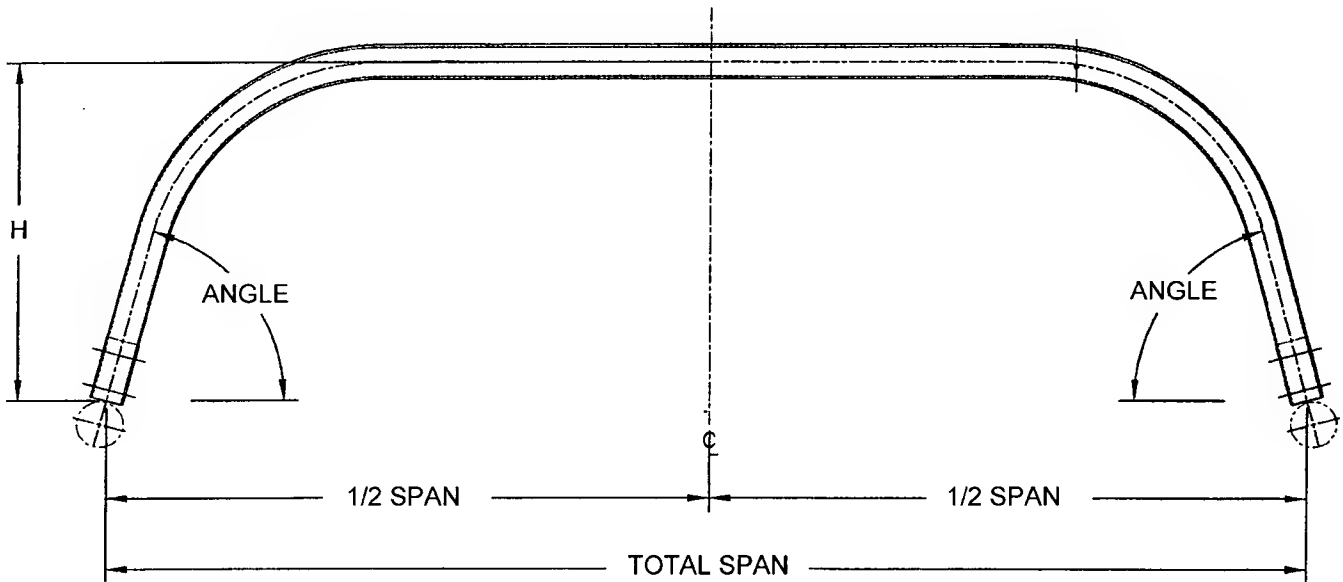
☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.241	✓		
	2.180	+0.005/-0.000	2.180	✓		
	2.180	+0.005/-0.000	2.180	✓		
	2.237	+0.005/-0.000	2.237	✓		
	2.272	+0.005/-0.000	2.272	✓		
	2.306	+0.005/-0.000	2.306	✓		
	2.339	+0.005/-0.000	2.339	✓		
	2.339	+0.005/-0.000	2.339	✓		
	0.062	+/-0.010	.062	✓		
	4.26	+/-0.030	4.26	✓		
	R0.063	+/-0.010	.063	✓		
	R0.50	+/-0.030	.500	✓		
SIDE B	2.240	+0.005/-0.000	2.240	✓		
	2.180	+0.005/-0.000	2.180	✓		
	2.180	+0.005/-0.000	2.180	✓		
	2.237	+0.005/-0.000	2.237	✓		
	2.272	+0.005/-0.000	2.272	✓		
	2.306	+0.005/-0.000	2.306	✓		
	2.339	+0.005/-0.000	2.339	✓		
	2.339	+0.005/-0.000	2.339	✓		
	0.062	+/-0.010	.062	✓		
	4.26	+/-0.030	4.270	✓		
	R0.063	+/-0.010	.063	✓		
	R0.50	+/-0.030	.50	✓		
	110.27	+/-0.060	110.27	✓		

<b>Measured by:</b> J.F.	<b>Audited by:</b> BG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/03/03	<b>Date:</b> 07.03.07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.09	New Issue (P/O D350-748-101)	KJ/JLM	B

## Crosstube Bend Dimension Sheet



PART NUMBER: \_\_\_\_\_

BATCH NUMBER: 31013A

DRAWING: \_\_\_\_\_ REVISION: \_\_\_\_\_

H: \_\_\_\_\_

1/2 SPAN: \_\_\_\_\_

TOTAL SPAN: \_\_\_\_\_

ANGLE: \_\_\_\_\_

QC 15: \_\_\_\_\_

DATE: \_\_\_\_\_

QTY: \_\_\_\_\_





DESIGN <i>90</i>	DRAWN BY <i>90</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>##</i>	APPROVED <i>##</i>	DRAWING NO. D350-748-141	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI FWD) NTS	
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6017-115 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

RELEASED

06.10.31 *##*

QTY	P/N	DESCRIPTION
X	D350-748-141	CROSSTUBE ASSEMBLY (AS 350/355 HI FWD)
1	D6017-115	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

#### D350-748-141 CROSSTUBE:

- 1) MATERIAL: MANUFACTURED FROM D6017-115 OR D6015-125  
FINISHED LENGTH =  $110.27 \pm 0.06$
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING **STYLUS**
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR  $\varnothing 0.297$  HOLE.

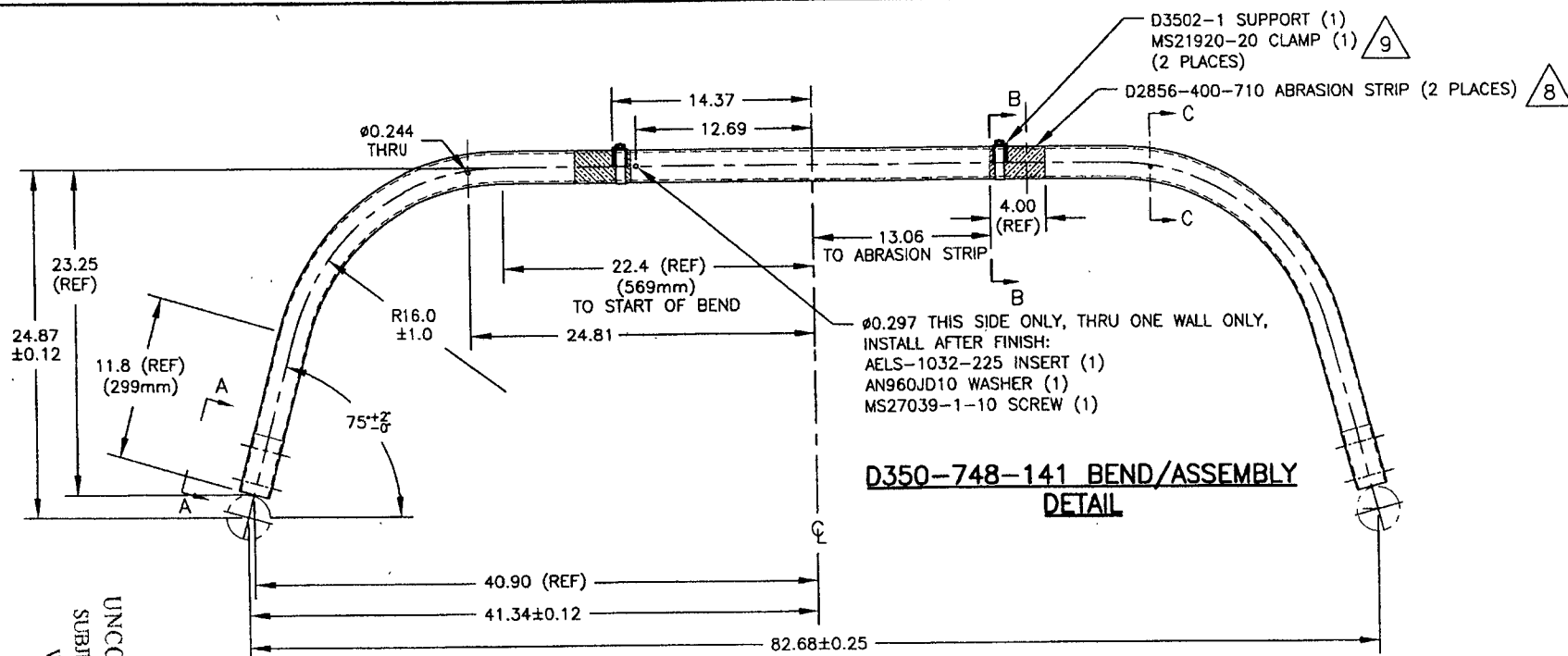
OK *9/27/01*  
**UNDER REVIEW**  
07.02.16  
COPY BEING REDUCED

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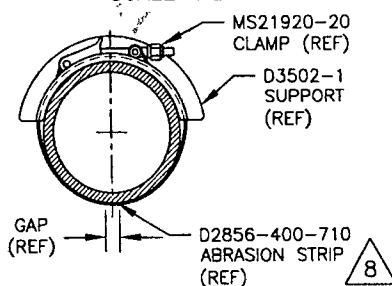






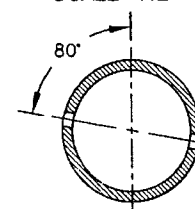
### SECTION B-B

SCALE 1:2



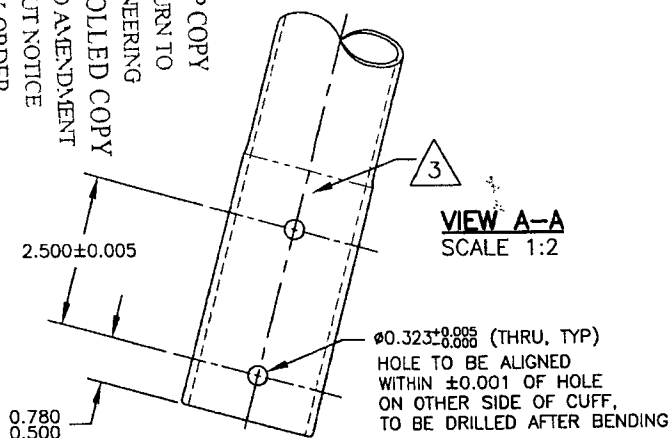
### SECTION C-C

SCALE 1:2



### VIEW A-A

SCALE 1:2



## D350-748-141 BEND/ASSEMBLY DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31013A

UNDER REVIEW

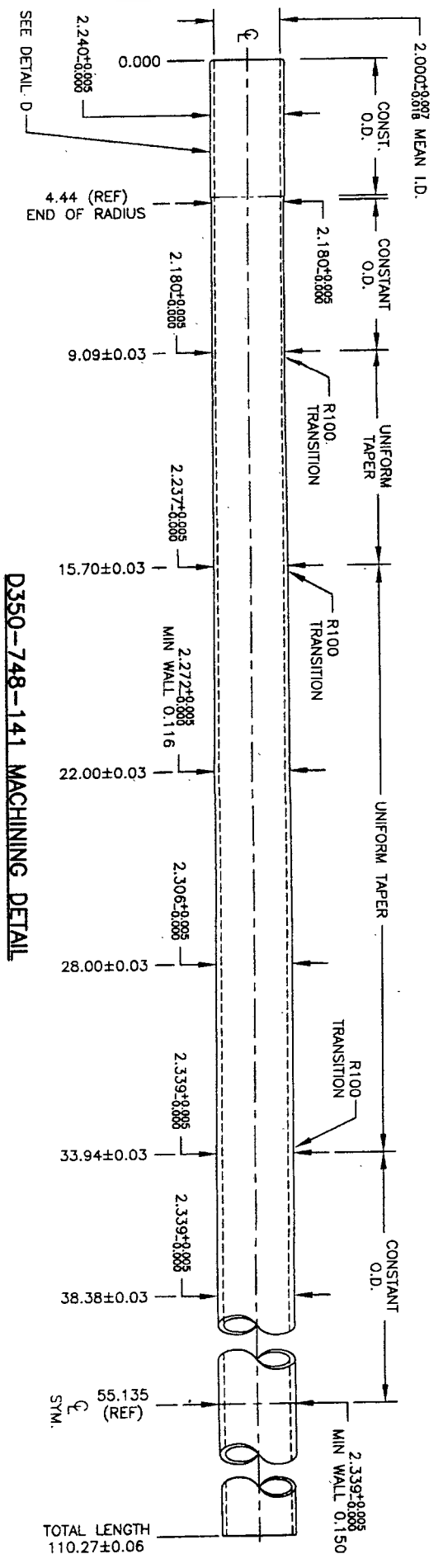
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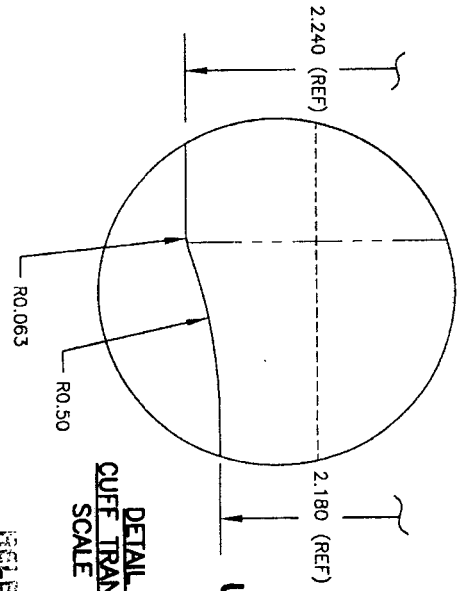
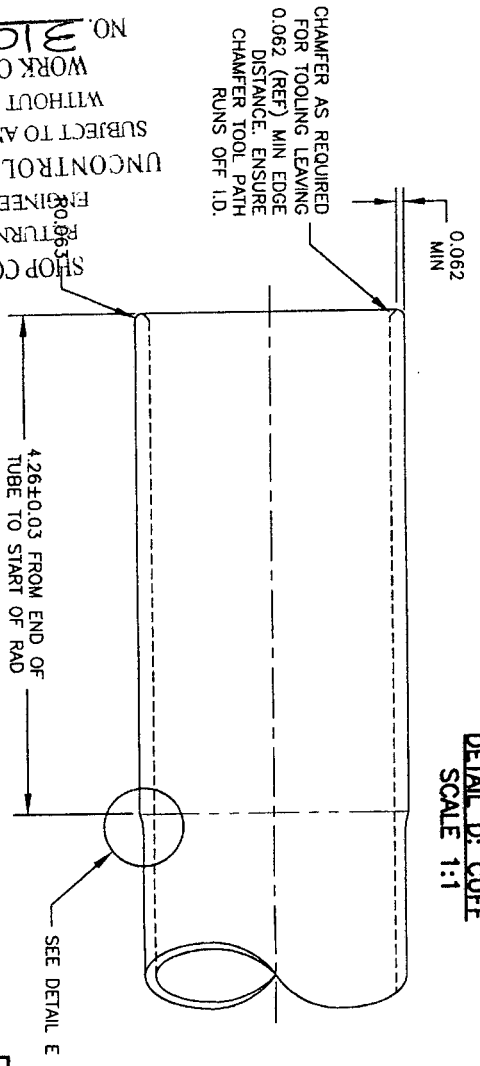
DESIGN	97	DRAWN BY	97	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	D350-748-141
DATE	06.10.31	TITLE	CROSSTUBE (AS 350/355 HI FWD)	REV. D	SHEET 2 OF 3
		SCALE	1:8		





**D350-748-141 MACHINING DETAIL**

**DETAIL D: CUFF**  
SCALE 1:1



**DETAIL E: CUFF TRANSITION**  
SCALE 9:1

**UNDER REVIEW**

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 31013A

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR ON ANY INFORMATION CONTAINED HEREIN WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	APPROVED	D350-748-141	REVISION
DATE	06.10.31				
CROSS TUBE (AS 350/355 HI FWD)		SCALE 1:3			

RELEASED  
06.10.31





**VAC AERO**  
INTERNATIONAL INC.

# PACKING SLIP

OAK 85250-1

04/13/2007

MM / DD / YYYY

GST No. : R105468102

PAGE : 1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

BILL TO:

1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
04/13/2007		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
274744		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D350-748	-141	EA	6	6	0
Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI PER AMS. 2759-1C 100% HARDNESS TESTED AS PER ASTM. E-18, HRC 40-43 MATERIAL: 4130 B31012A, B31014A, B31013A, B31015A, B31017A, B31016A						
02	LC	LOT CHARGE		1	1	C

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING - HEAT TREATING - SPECIAL PROCESSING - FURNACE EQUIPMENT  
LASER CUTTING - PLASMA AND OTHER COATINGS







**VAC AERO**  
INTERNATIONAL INC.

**RELEASE NOTE**

GST No.: R105468102

OAK 85250-1

☒ **HEAD OFFICE**  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489

☐ **2009 WYECROFT ROAD, UNIT B**  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380

☐ **QUEBEC DIVISION**  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

04/13/2007

MM / DD / YYYY

PAGE: 1

**BILL TO:**  
1DAR01  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

**SHIP TO:**  
DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
04/13/2007		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
274744		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-748	-141	EA	6	6	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180 KSI PER AMS 2759-1C 100% HARDNESS TESTED AS PER ASTM E-18, HRC 40-43 MATERIAL: 4130</p> <p>B31012A, B31014A, B31013A, B31015A, B31017A, B31016A</p>					
<div><div>100% HARDNESS TESTED</div><div>Qty: 06 Pcs</div><div>42/43 HRC</div><div>15 Apr 07</div></div> <div>V.A.I.O. TH. 28 Q.C.</div>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



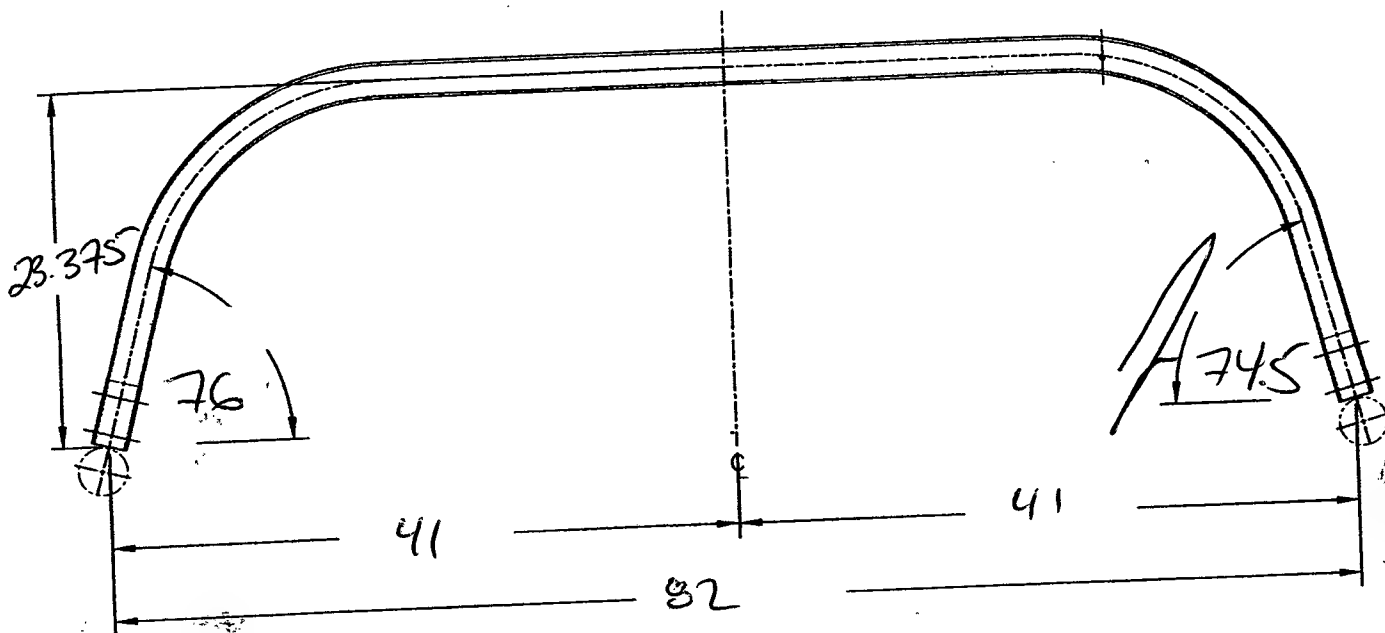
HEAT  
TREATING





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 31013
<b>Description:</b> Crosstube High Fwd (AS350/355)		<b>Part Number:</b> D350-748-101
<b>Inspection Dwg:</b> D350-748-141 <b>Rev:</b> D		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	23.13	23.37
1/2 Span	40.78	41.02
Angle	75	77
Total Span	81.56	82.04



Comments

QC15 Inspection	<i>[Signature]</i> 0705-2
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	



**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** May-29-2007

**CONIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 67187

**INVOICE #:** 34601

**CONTRACT OR  
PURCHASE ORDER #**

3730

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** D350748141

**S/N #** B31013A

CADMIUM PLATE IAW AMS-QQ-P-416 TYPE 2 CLASS 1. MPI IAW  
ASTM-E-1444. BAKE HEAT CHARTS #7795, #7797, #7838.

**CERTIFICATE:** I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.

**Approved Inspector:**

*William Maruszynski*



# Packing Slip



## Cadorath Plating Co. Ltd.

2150 Logan Avenue, Winnipeg, Manitoba R2R-0J2

Phone: (204) 633-9420 Fax: (204) 633-8033

**Sold To:**

Dart Aerospace Ltd.  
1270 Aberdeen St.

Hawksbury, ON K6A 1K7

**ShipTo:****INVOICE NUMBER:**

34601

Net 2% Interest Per Month charged on Overdue Accounts.

Any claims for shortages, overcharges, or damaged goods must be made within seven (7) days from receipt of goods.

Customer Order #:	Date Received:	Terms:	G.S.T. #:	Ship Via:	Ship Date:
3730	May-15-2007	NET 30 DAYS	10071 6547 RT0001		May-29-2007

Item # Qty P/N & Description

1	1 EA	SKID	S/N B31013A
		P/N D350748141	W/O 67187
2	1 EA	SKID	S/N B31014A
		P/N D350748141	W/O 67188
3	1 EA	SKID	S/N B31016A
		P/N D350748141	W/O 67189
4	1 EA	SKID	S/N B29762A
		P/N D350748241	W/O 67190
5	1 EA	SKID	S/N B29764A
		P/N D350748241	W/O 67191
6	1 EA	SKID	S/N B29765A
		P/N D350748241	W/O 67192

